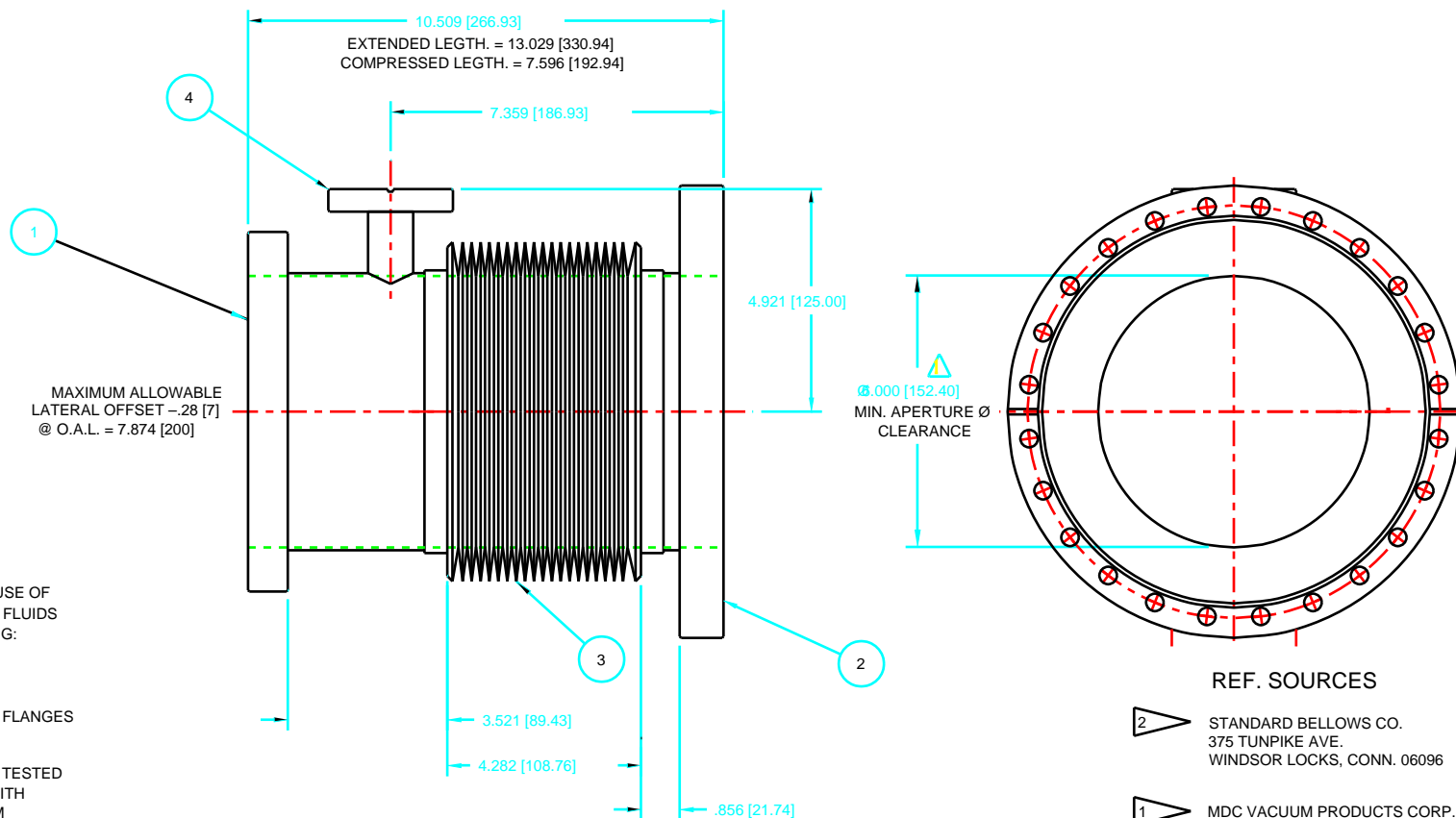


4 3 2 1



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF  $2 \times 10^{-10}$  STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS

ALCATEL SAM-110TCL  
Du PONT CEC 24-120B  
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [ ] ARE MILLIMETERS

REF. SOURCES

- 2 STANDARD BELLOWS CO.  
375 TUNPIKE AVE.  
WINDSOR LOCKS, CONN. 06096
- 1 MDC VACUUM PRODUCTS CORP.  
23842 CABOT BLVD.  
HAYWARD, CA. 94545-1651

4	MDC'C CAT. #110012	2 3/4" CF. NONROTATABLE FLANGE	1
3		ST'D. BELLOWS CAT. #750 - 600 - 5 - EE	1
2	MDC'S CAT. #100032	10" CF. ROTATABLE FLANGE	1
1	MDC'C CAT. #110031	8" CF. NONROTATABLE FLANGE	1

ITEM	SYM/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, LOG NUMBER ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGLES				
.1 .03 (.7620) .25				
.02 .01 (.025)				
.005 .005 (.0127)				
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ.				
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST 944				
POLISHING & POLISHING TO ACCORDANCE WITH LATEST ASST 944				
DO NOT SCALE DRAWING				
THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY				
V2960000-01				
DRAWN BY MUSCIA DATE 11/17/99				
CHECKED BY D. SHU DATE 7/6/99				
DESIGNER SHU/MUSCIA DATE 7/6/99				
RESPONSIBLE ENGINEER D. SHU DATE 7/6/99				
APPROVED/RELEASED				
MATERIAL SEE PARTS LIST				
SCALE HALF SIZE				
SHEET 1 of 1				
DRAWING NUMBER V2-960000-01				

1	V2960000-01 WAS A14778			
	V2-960000-01 WAS			
	410509702-960000-00			
	(NEW LOG # & PART #)			
	0.000 [152.40] WAS 0.000 [101.60]	M.J.M.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				